Each

8 Um:

Tuesday, 4/18/2006 10:07:04 AM Kim Johnston User: **Process Sheet** : PLATE : CU-DAR001 Dart Helicopters Services **Drawing Name** Customer : 26691 Job Number : 10424 **Estimate Number** : NIA : D33031 Part Number P.O. Number : D3303 REV. A S.O. No. : N/A : 4/18/2006 **Drawing Number** This Issue : NC Project Number : N/A Prsht Rev. : N/A : MACHINED PARTS Type **Drawing Revision** First Issue : NIA : 22107 Material **Previous Run** : 5/20/2006 Qty: **Due Date** Written By Checked & Approved By : Est:A New issue KJ/JLM Comment **Additional Product** Job Number: **Machine Or Operation:** Description: Seq. #: 2024-T3 .032 sheet M2024T3S032 1.0 Comment: Qty.: 0.3719 sf(s)/Unit Total: Material: 2024-T3 (QQ-A-250/4) 0.032" thick (M2024T3S.032) SHEAR 2.0 SHEAR Comment: SHEAR Cut blank: 9.200" x 5.050" HAAS CNC VERTICAL MACHINING #1 3.0 HAAS1 Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA460 and Dwg D3303 Identify as D3303-1



INSPECT PARTS AS THEY COME OFF MAC

SECOND CHECK

 \mathcal{S} 6605-13

4.0

5.0

QC2

QC8

Comment: SECOND CHECK

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Dart Ae	rospace L	td							
W/O:			W	ORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory: i	NCR: Yes	No DQ	A: 2	<u>}</u> Date: <u></u>	40/05/25
					QA: N	I/C Close	d:	_ Date: _	
NCR:		,	WORK ORD	ER NON-CONFORMAN	CE (NCF	₹)	,		
D.4.T.F	0750	Description of NC		Corrective Action Section E		Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Sect	ion C		QC Inspector
							1		

NOTE: Date & initial all entries

Tuesday, 4/18/2006 10:07:04 AM Date: User: Kim Johnston **Process Sheet Drawing Name: PLATE** Customer: CU-DAR001 Dart Helicopters Services Part Number: D33031 Job Number: 26691 Job Number: Description: Seq. #: **Machine Or Operation:** SMALL & MEDIUM FAB RESOURCE 1 SMALL FAB 1 6.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr INSPECT WORK TO CURRENT STEP QC5 7.0 Comment: INSPECT WORK TO CURRENT STEP 8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1 Comment: HAND FINISHING RESOURCE #1 SAD Chemical Conversion Coat as per QSI 005 4.1 INSPECT POWDER COAT/CHEMICAL CONVERSION 9.0 QC3 CHEMICAL CONVERSION COAT PACKAGING RESOURCE #1 10.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 11.0 DC Comment: DOCUMENT CONTROL Inspection Level 21 Job Completion CZ06165125

Dart Aerospace Ltd

DuitAu	·ospace	- Lu							
W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cator	Jones .	NCP: You	No DOA		Data	
raitivo	•	FAI\#.	Fauit Cate(gory				_ Date: _ _ Date: _	
NCR:			WORK ORD	R NON-CONFORMA	NCE (NCF	()			
DATE	OTED	Description of NC	· · · · · · · · · · · · · · · · · · ·	Corrective Action Section B		Verification		Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	n Description Sign & Date		Section C	Chief Eng	QC Inspector
									į

NOTE: Date & initial all entries

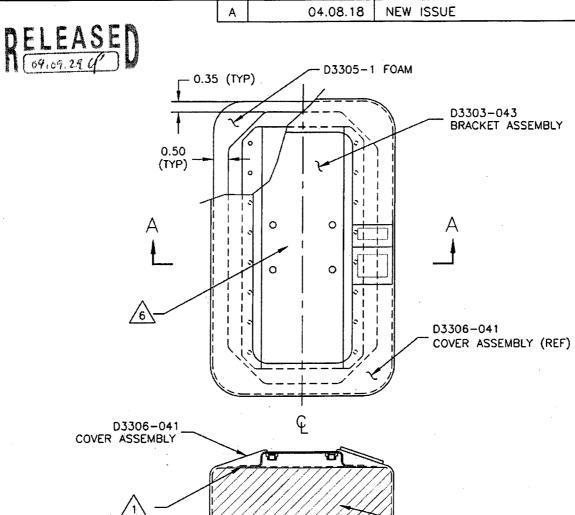
DART AEROSPACE LTD	Work Order:	26691
Description: Plate	Part Number:	D3303-1
Inspection Dwg: D3303 Rev: A		Page 1 of 1

FIRS	T ARTICLE II	NSPECTI	ON CHI	ECKLIST		
	First Arti	cle	Prot	otype		
Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Con	nments
+/-0.010	5006	V		vern		
+/-0.005	3.560	1		T		
+/-0.030	1224450			Mara la tata	~	
+/-0.030	Rn 25	1		RADIUS	·	
+/-0.030	9 09	V		11000		
+/-0.005	7,000			1 ' '		
+/-0.005	1.000	1		LOIN		
+/-0.010	1,052	V		Hightowar		
+/-0.010	728	1		vern		
+/-0.010	0.032	/		yern		
					·	
		-,				
M M	Audited by:	2		Prototype Appr	oval:	N/A
1 2 1	Date:	0605.			Date:	N/A
	Tolerance +/-0.010 +/-0.005 +/-0.030 +/-0.030 +/-0.005 +/-0.005 +/-0.010 +/-0.010	X First Arti Tolerance	X First Article	X First Article	Tolerance	X First Article

	Rev	Date	Change	 KI/II M	Approved
	Α	04.09.08	New Issue	 KJ/JLM of	
•				()	/~/



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DESIG	RF	DRAWN BY RF	DART AEROSP HAWKESBURY, ONTAR	
CHECK	ED A	APPROVED	DRAWING NO.	REV. A
	#	At .	D3303	SHEET 1 OF 4
DATE		<u>.L</u>	TITLE	SCALE
04.0	8.18		HEAD REST	1:3
Α		04.08.18	NEW ISSUE	



SECTION A-A

D3303-041 HEAD REST

SHOP COPY

RETURN TO

D3303-041 NOTES:

ENGINEERING 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIXENTROLLED COPY (0.002" to 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS

2) COVER HEAD REST WITH D3306-041 AS SHOWN

SUBJECT TO AMENDMENT WITHOUT NOTICE

D3305-1 FOAM

3) PART IS SYMMETRIC ABOUT CENTERLINE
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

work order no. 26691

ALL DIMENSIONS ARE IN INCHES

6) IDENTIFY AS FOLLOWS USING FINE POINT PERMANENT INK MARKER:

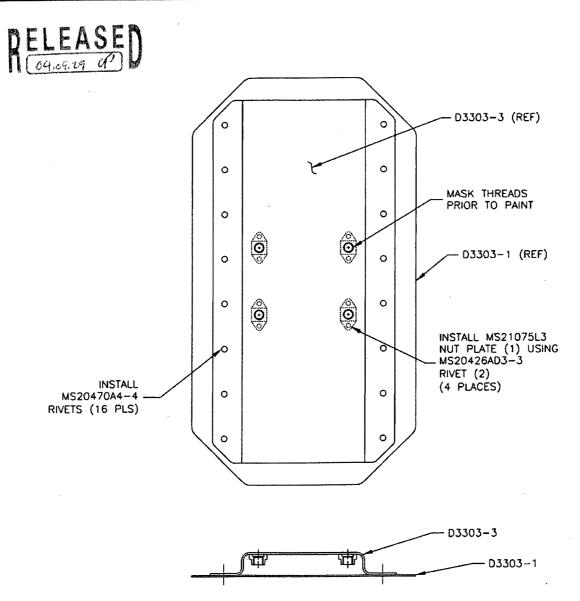
"TCCA-PDA, DART AEROSPACE LTD, P/N D3303-041 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

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CHECKED	APPROVED	DRAWING NO.	REV. A
780		D3303	SHEET 2 OF 4
DATE		TITLE	SCALE
04.08.18		HEAD REST	1:1



D3303-043 BRACKET ASSEMBLY

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. ENGINEERING

UNCONTROLLED COPY SUBJECT TO AMENDMENT

1) FINISH: POWDER COAT ASSEMBLY GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3 WITHOUT NOTICE
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMFNSIONS ARE IN INCLESS

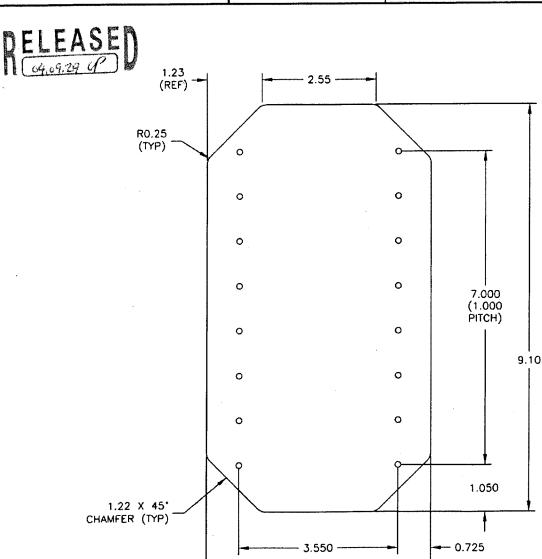
3) ALL DIMENSIONS ARE IN INCHES

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CHECKEDA	APPROVED	DRAWING NO.	REV. A
#	1	D3303	SHEET 3 OF 4
DATE		TITLE	SCALE
04.08.18		HEAD REST	1:2



D3303-1 PLATE

5.00 -

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03303-1 NOTES:

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK SHEET (REF. DART SPEC M2024T32\$1032) EERING FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005 4.1 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED UNCONTROLLED

UNCONTROLLED COPY SUBJECT TO AMENDMENT

ALL DIMENSIONS ARE IN INCHES BREAK ALL SHARP EDGES 0.005 TO 0.015

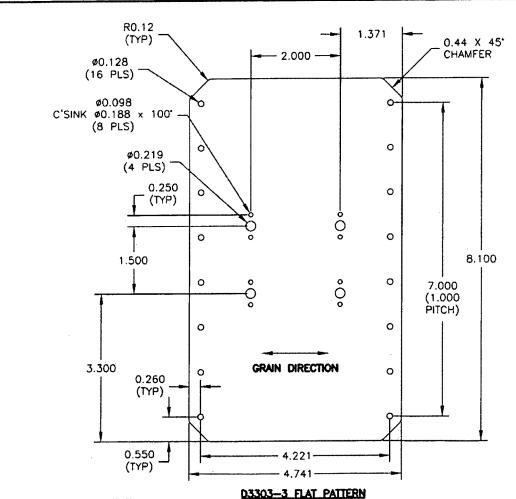
WITHOUT NOTICE

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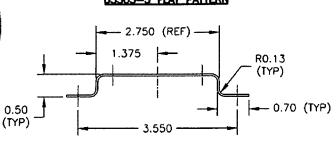
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#	At the	D3303	SHEET 4 OF 4
DATE		TITLE	SCALE
04.08.18		HEAD REST	1:2



RELEASED OF CO. 29 CP



D3303-3 BRACKET BEND DETAIL

SHOP COPY RETURN TO ENGINEERING

CONTROLLED COPY SUBJECT TO AMENDMENT

WITHOUT NOTICE

- 03303-3 NOTES: MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK SHEET (REF. DART SPEC M2024T32S,040)K ORDER FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005 4.1
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

 NO. 26691 NO 26691

4) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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